Date: Tuesday, 11/21/2006 11:40:11 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: SKIDTUBE ASSEMBLY
Job Number	: 29583		
Estimate Number	: 10022		
P.O. Number	: N/A	**Part Number**	: D205634011
This Issue	: 11/21/2006 **S.O. No.** : N/A	**Drawing Number**	: N/A
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LANDING GEAR	**Drawing Revision**	: N/A
Previous Run	: 29582	**Material**	: N/A
Written By	:	**Due Date**	: 12/4/2006 **Qty:** 1 **Um:** Each
Checked & Approved By	: 06 11 21		
Comment	: Est Rev:P 02.08.28 Removed QC5 from Step 5 KJ		

Additional Product

Job Number:

Seq. #:	**Machine Or Operation:**	**Description :**
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy bluefile & type labels per PPP D205-634-011 CHG004 KJ 06.11.27 (1)

2.0	29583A	SKID TUBE ASSEMBLY

Comment: Sub-Component SKID TUBE ASSEMBLY
D205-634-041 B 29583A

3.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick Packing Kit

4.0	K10003	D205-634-011 Saddle Kit

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	K10003	Saddle Kit	B29683
1	D205-634-041	Skidtube Assembly(ref)	B29583A

7/01/16 (1)

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS

Comment: INSPECT 100% KITS FOR COMPLETENESS SB 07/01/16 (1)

Form: rprocess

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes (No) **DQA:** [signature] **Date:** 07/01/17

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 11:40:12 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY

Job Number: 29583

Part Number: D205634011

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D205-634-011
Location: ________

Seq. #:	Machine Or Operation:	Description :
7.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

Form: rprocess

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Tuesday, 11/21/2006 11:40:45 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: SKID TUBE ASSEMBLY
Job Number	: 29583A		
Estimate Number	: 10023		
P.O. Number	: N/A	**Part Number**	: D205634041
This Issue	: 11/21/2006 **S.O. No.** : N/A	**Drawing Number**	: D2580 REV C
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LANDING GEAR	**Drawing Revision**	: C
Previous Run	: 29476	**Material**	: N/A
Written By	:	**Due Date**	: 12/4/2006 **Qty:** 1 **Um:** Each
Checked & Approved By	: 06 11 21		

Comment : Est Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
Est Rev. O 06.02.28 Added paperwork EC

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy D205-634 bluefile & type labels per PPP D205-634 CHG001 N/A

Seq. #:	Machine Or Operation:	Description :
2.0	D25001190	Ext'n -'I' Beam Tube 4"

Comment: Qty.: 1.0400 Each(s)/Unit Total : 1.0400 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2500-1-190	Skid Tube Extrusion	B25858 PMC M.A 06/11/23

Seq. #:	Machine Or Operation:	Description :
3.0	D2596	205 Web

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2596	205 Web	B29455 RT 06-11-23

Seq. #:	Machine Or Operation:	Description :
4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage PMC M.A 06/11/23

2-Cut D2500-1-190 per Dwg D2580 if necessaryDeburr ends DP 6-11-23

3-Acid etch and Alodine tube per QSI 005 4.1 PMC M.A 06/11/23

4-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid) DP 6-11-23

Form: rprocess

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 11:40:45 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | **Drawing Name:** SKID TUBE ASSEMBLY

Job Number: 29583A | **Part Number:** D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :

5-Open holes to 0.500" as per Dwg D2580without cutting fluid

6-Countersink holes as per Dwg D2580without cutting fluid

7-Deburr and blow out all chips from inside of tube

DP 6-11-23

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting
Pick:

Qty	Part Number	Description	Batch
A/R	Sikaflex-291		B(0)660

Sikaflex expire date: 07-02-01
Start Time: 3:00 Date: 06-11-23
Fin Time: 10:45 Date: 6-11-24

ET 06-11-23

5.0	BENDING	BENDING MACHINE

Comment: BENDING MACHINE
1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

DP 6-11-24

6.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes

DP 6-11-30
ET 06-11-30

7.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

AA 06/11/29

8.0	D25763	Step (Machining Detail)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	B-23060

BE 06-11-30

 Form: rprocess

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W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 11:40:45 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: SKID TUBE ASSEMBLY

Job Number: 29583A
Part Number: D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
9.0	D2579	Crossbolt Spacer

Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	D2579	Spacers	B29489 BE 06-11-30

Seq. #:	Machine Or Operation:	Description :
10.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 StepRemove alodine as required. BE 06-11-30

2-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.
For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill BE 06-11-30
A/R Aluminum Rod M10655

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending PM 06-12-5 (1)

4-Drill holes for wearplates using DT 8217Open holes to 19/64", adjust stopper not to hit web.Deburr PM 06-12-5 (1)

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes PM 06-12-5 (1)

6-Drill pilot holes for aft cap using DT 8215Open holes to #6 Drill bit. Deburr PM 06-12-5 (1)

7-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr PM 06-12-5 (1)

8-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R Aluminum Rod M10655 BE 06-11-30

Seq. #:	Machine Or Operation:	Description :
11.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION 06/12/05 (1)

Seq. #:	Machine Or Operation:	Description :
12.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP 06/12/05 (1)

Form: rprocess

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 11:40:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SKID TUBE ASSEMBLY

Job Number: 29583A **Part Number:** D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
13.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

M102341

Comment: HAND FINISHING RESOURCE #1
Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3 m-k / a.m 06/12/14

14.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 01/01/02 (1)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0	D25771	Wearplate Fwd

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2577-1	Wearplate	B29488

16.0	D25773	Wearplate Aft

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2577-3	Wearplate	B29326

17.0	D25775	Wearplate, Centre

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2577-5	Wearplate	B28639.

18.0	ALS71032130	Insert

Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
44	ALS7-1032-130	Inserts	MB19393

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Tuesday, 11/21/2006 11:40:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: SKID TUBE ASSEMBLY

Job Number: 29583A
Part Number: D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
19.0	AN960JD10L	Washer

Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4 4	AN960JD10L	Washer	102217

Seq. #:	Machine Or Operation:	Description :
20.0	AN34A	Bolt

Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
44	AN3-4A	Bolt	102832

Seq. #:	Machine Or Operation:	Description :
21.0	D25941	Plug

Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
plug
Batch: B28014

Seq. #:	Machine Or Operation:	Description :
22.0	D25943	O-Ring

Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
o-ring
Batch: B27168

Seq. #:	Machine Or Operation:	Description :
23.0	D2855	Cap

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Cap
Batch: B26351

Seq. #:	Machine Or Operation:	Description :
24.0	AN35A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: M15205

Dart Aerospace Ltd

29955

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes / No (circled) DQA: [initials] Date: 07/01/17

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 11:40:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: SKID TUBE ASSEMBLY

Job Number: 29583A
Part Number: D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
25.0	AN960JD10L	Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
Batch: B102217

26.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R Sikaflex-291 DNV0575
Sikaflex expire date: 02/2007

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 DNV0575
Sikaflex expire date: 02/2007

5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch:
M103084 07/02/01

27.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

28.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D205-634-041
Location:____________
PPP Rev:____________
N/A

29.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE 07/01/17

07 01.17

Form: rprocess

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

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Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2580 — REV. C — SHEET 1 OF 2
DATE 98.08.26		TITLE 205 SKIDTUBE ASSEMBLY — SCALE NTS

DART

QA COPY ISSUED

RELEASED 98/09/17 DS

REV	DATE	DESCRIPTION
A	96.09.16	NEW ISSUE
B	96.12.02	AS MANUFACTURED
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097

QTY	Part Number	Description
X	D2580-041	SKIDTUBE ASSEMBLY
*	D2500-1	EXTRUSION
1	D2596	205 WEB
1	D2575	AFT CAP
1	D2576-3	STEP
20	D2579	CROSS BOLT SPACER
16	D2594-1	PLUG
16	D2594-3	O-RING
1	D2577-1	WEARSHOE
1	D2577-3	WEARSHOE
1	D2577-5	WEARSHOE
44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
46	AN3-4A	BOLT
46	AN960JD10L	WASHER

00.08.28
00.08.28

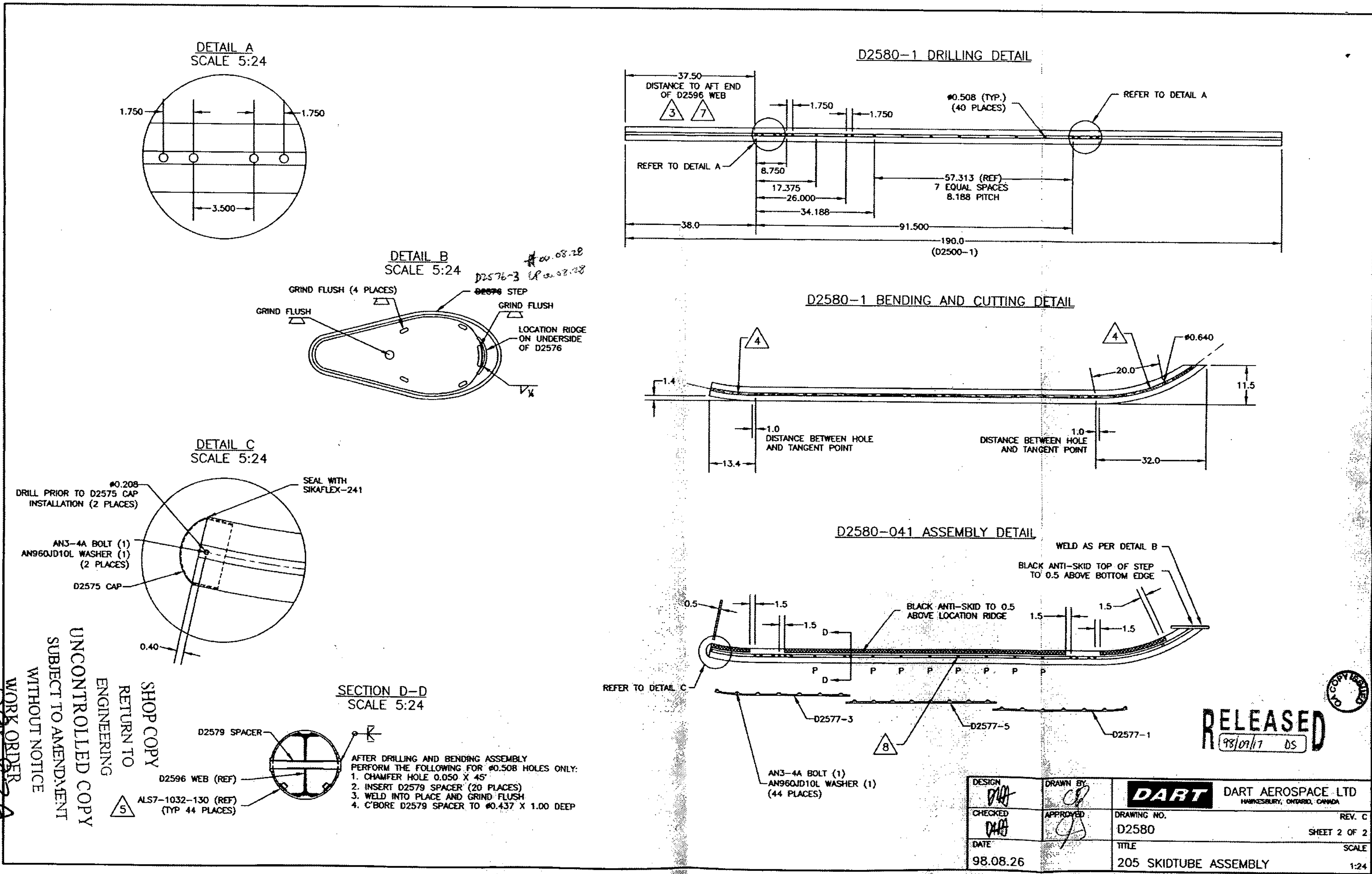
EFFECTIVE DEOs: DEO 9124 98/12/14; DEO 9183 00.08.28

GENERAL NOTES:

1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES *
3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (44 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
6) WELDING TO BE DONE PER DART QSI 004.
7) FINISH:
   ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
   POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
   BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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WORK ORDER NO. 29583A

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NO. 80

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number 205 634 041 / B29469 A

TEST WELDS REQUIRED

BASE METAL Alum **WELDING PROCESS** Tig
Penetration Complete [ ] Partial [✓] **Single Weld** [✓] **Double Weld** [ ]
Current AC [✓] DC [ ] **Backing** YES [ ] NO [✓]

Position **Vertical** Down [ ] Up [ ]

Sheet Groove	1G [ ]	2G [ ]	3G [ ]	4G [ ]
Tube Groove	1G [ ]	2G [ ]	5G [ ]	6G [ ]
Sheet Fillet	1F [ ]	2F [ ]	3F [ ]	4F [ ]
Tube Fillet	1F [ ]	2F [ ]	4F [ ]	5F [ ]

N/A

Crossbolt Spacer Welded into ______________ Skidtube

TEST RESULTS

Visual	Pass [✓]	Fail [ ]
Penetration	Pass [✓]	Fail [ ]
Crossbolt Spacer	Pass [✓]	Fail [ ]

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/11/29 **Qualifier** [signature]